

# Work Order ID 83322

Tuesday, April 17, 2012 1:16:10 PM

**\*83322\***

Page 1

Item ID: D2734 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step End Plate  
 Start Date: 4/17/2012 Start Qty: 30.00 **\*30\*** Cust Item ID:  
 Required Date: 4/25/2012 Req'd Qty: 30.00 **\*30\*** Customer:  
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12-04-17 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2734	Rev C

100	FLOW WATER JET	0.00							
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**\*100\***  
 Waterjet  
 FLOW CNC Waterjet  
 5052.063

Memo  
 1-Cut as per Dwg D 2734  
 Dwg Rev: C  
 Prog Rev: C  
 2-Deburr if necessary

30 *[initials]* JM  
 12-5-12

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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**\*110\***  
 QC  
 Quality Control

Memo

30 *[initials]* JM  
 12-5-12

120	QC8- Inspect parts - second check	0.00							
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**\*120\***  
 QC  
 Quality Control

Memo

8/15/14

cautels  
 (Y30)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date		Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Small Fab	Small Fab	0.00				30			80 12/05/16
Small Fab	Memo	0.00							
Small Fab	Form as per drawing D2734								
140 <b>*140*</b> QC	QC5- Inspect part completeness to step on W/O	0.00				count 30			
Quality Control	Memo	0.00							
150 <b>*150*</b> Packaging	Identify as per dwg & Stock Location: <i>WNA</i>	0.00				30	0		12 12.05.16
Packaging	Memo	0.00							
	*** STOCK IN STEP CELL***								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Required Date: 4/25/2012 Req'd Qty: 30.00 **\*30\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

12/15/17   
ME  
12-05-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, April 17, 2012 1:16:30 PM

Page 1

Work Order ID: 83322

**\*83322\***

Parent Item: D2734

**\*D2734\***

Parent Item Name: Step End Plate

Start Date: 4/17/2012

Required Date: 4/25/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: D01.06.08Removed DeburrEC  
IPP Rev:E 07-12-18 RevC as per dwg ECN1048 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased			No	100	sf	67.8526	0.0625	1.973684			

**\*M5052H32S 063\***

**\*\***

5052-H32 .063 Sheet

Location

Loc Qty

Loc Code

MAT022

67.852632

114322

12.852632

120603

55

120603

JM/S  
12-5-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





W/O:

## WORK ORDER CHANGES

DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:

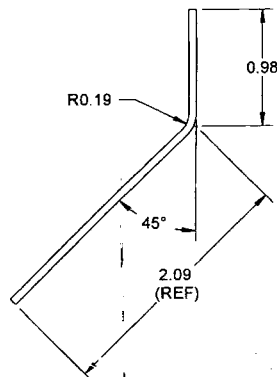
## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

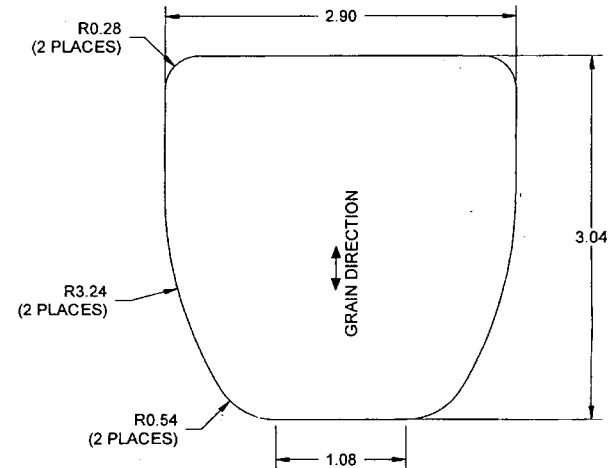
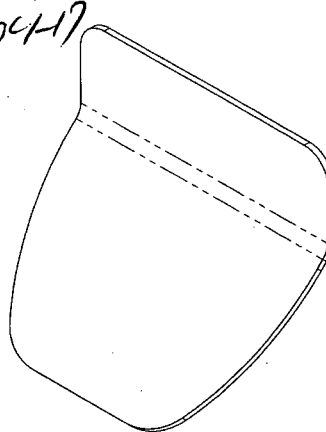
NOTE: Date &amp; initial all entries

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 83322

*120417*



**D2734 END PLATE**



**D2734 FLAT PATTERN**

**RELEASED**  
*07.12.16*

**NOTES:**

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET  
 PER AMS-QQ-A-250/8 OR AMS 4016  
 (REF. DART SPEC. M5052H32S.063) OR  
 6061-T6 (OR 6061-T6) ALUMINUM SHEET  
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs

C	ADD GRAIN DIRECTION NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.20
B	0.976 WAS 1.016, 2.097 WAS 2.137	KE	98.10.05
A	NEW ISSUE	KE	97.12.10
REV.	DESCRIPTION	BY	DATE
DESIGN	KE		
DRAWN	BC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.20		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. C
DRAWING NO.	D2734	SHEET 1 OF 1
TITLE	END PLATE	SCALE 1:1

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W/O:		WORK ORDER CHANGES							
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